



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM642V4001102-9

Job Sheet 173766



Part No: RBEM642V4001102-9

Job Qty: 4 ea

Part Name: Knob Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/7/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEM642V4001102 REV 2 IPP REV A 18.03.05 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		3/29/18	0.00	0.00	Start Up Large Fab-7		EZ
100	Large Fab	4 pcs		3/30/18	0.08	0.33	Large Fab 8		EZ
110	QC	4 pcs		3/30/18	0.00	0.00	QC9		PD 18-05-10
130	Packaging	4 pcs		3/30/18	0.00	0.00	Packaging3-2		MAY 10 2018
140	QC21-SA	4 Ea		3/30/18	0.00	0.00	QC21		MAY 10 2018

Part Op 100 - 1- Assemble & weld RBEM642V4001102-11 to RBEM642V4001102-13 as per DWG
Descriptions: 130 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEM642V4001102-11	Knob	4 Ea (1 ea)	90-Start up Operation	5068457
RBEM642V4001102-13	Stud	4 Ea (1 ea)	90-Start up Operation	5068552

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBEM642V4001102-11	4	0	0
	RBEM642V4001102-13	4	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____ Step #: _____

Description Work Order Deviation

MRR (OSIN42) Approval

Container No: S069568
Part: RBEM642V4001102-9
Job No: 173766
Serial No/Batch: S069568
 Revision: 2
 Inspector: _____
 Date: 05/09/19

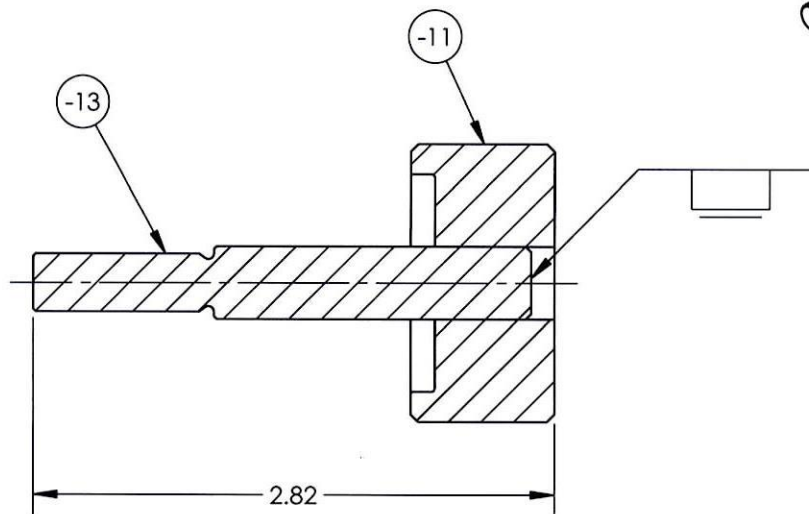
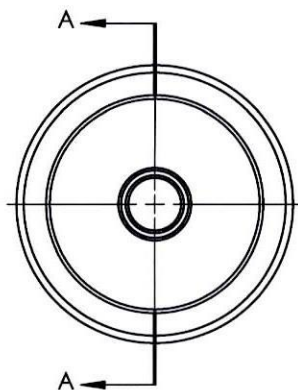


1270 Aberdeen Street
 Hawkebury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

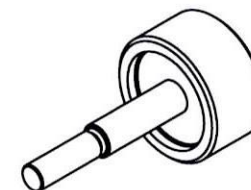
Root Cause			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	
Design ☐	Operator ☐	Bending ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		
		OTHER : _____	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0186	-9 REMOVED FINISH AND SPEC.	10/21/2016	SM	JAG



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173766

20180427
n

(-9)

KNOB WELDMENT

DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-9	REV 2
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 4/11/2016 SHEET 6 OF 11